

Work Order ID 96301***96301***

Page 1

Tuesday, January 22, 2013 3:01:43 PM

Item ID: D4482-4

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge Plate, RH

Start Date: 1/22/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *12-23* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4482

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *C*Prog Rev: *C*

2-Deburr if necessary

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HA
HA

Work Order ID 96301***96301***

Page 2

Tuesday, January 22, 2013 3:01:43 PM

Item ID: D4482-4

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Plate, RH

Start Date: 1/22/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

13.6 12

130

NC BRAKE

0.00

130

Small Fab

Memo

0.00

Small Fab

C'SINK HOLES AS PER DWG

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

DAS
05 13-01-29
9-89

Work Order ID 96301

Tuesday, January 22, 2013 3:01:43 PM

96301

Page 3

Item ID: D4482-4

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Plate, RH

Start Date: 1/22/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

SprayPaint

Memo

0.00

Spray Painting

Prime tempo grey as per dwg (note 2)
Batch: 117319DAS
05
2-89 13-02-294 0 0 11
13-2-19

Work Order ID 96301

96301

Page 4

Tuesday, January 22, 2013 3:01:43 PM

Item ID: D4482-4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge Plate, RH

Start Date: 1/22/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: ST110

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

DAS
05.13.03.05

4X

11.10.13-06-13

13/6/13

13-06-13

Picklist Print

Tuesday, January 22, 2013 3:01:42 PM

Page 1

Work Order ID: 96301

Parent Item: D4482-4

Parent Item Name: Hinge Plate, RH

Start Date: 1/22/2013

Required Date: 2/1/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:B 13.01.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

6061-T6 .080 Sheet

Purchased

No

sf

292.0686

~~0.5052632~~
0.5

Jm13-29

Location

Loc Qty

Loc Code

MAT021

292.068632

117285

0.248632

119766

39.82

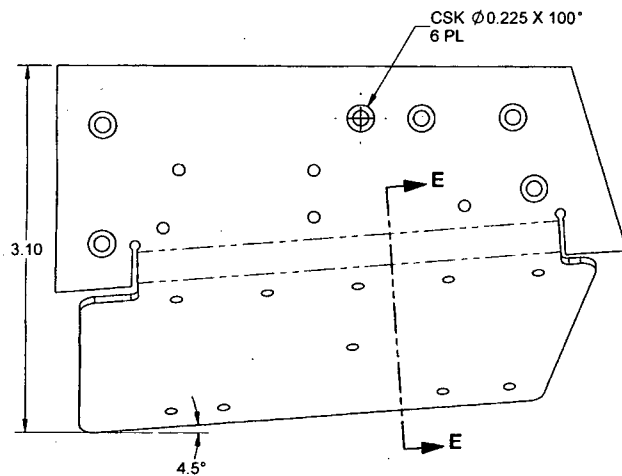
120096

168.8

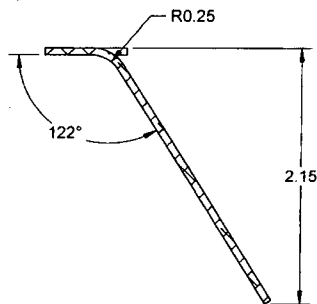
123279

83.2

123279



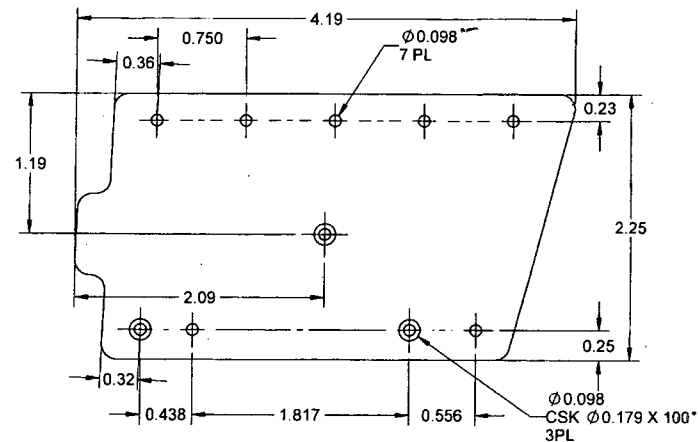
D4482-2 INTERCOSTAL 5 ASSY (RH)



SECTION E-E

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



D4482-4 HINGE PLATE (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REV.C.DXF"

RELEASED
2012-11-29

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4482	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	NTS
DATE	12.10.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

